

Work Order ID 63909

Thursday, November 18, 2010 3:53:43 PM

Page 1

Rush!!



Item ID: D4003-049

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Vent Line Assembly

Start Date: 11/19/2010 Start Qty: ~~2.00~~ *5*



Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *CMF*

Date: *10-11-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4003

A

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: *12968*
Manufacture as per Dwg D4003
Ship mat'l to vendor
Possible Supplier: Cintube
Material release note required

CZ 10/11/22 (5)

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Pu/pa/13 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 63909

Thursday, November 18, 2010 3:53:43 PM

Page 2

Item ID:	D4003-049	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Tank Vent Line Assembly					
Start Date:	11/19/2010	Start Qty:	2.00		Cust Item ID:	
Required Date:	12/3/2010	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC6- Inspect dimensions to drawing Memo All mat. supplied by Part	0.00 0.00		810113		(AS)			
121  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				X5 0		24 11/01/13	Ph →
122  Small Fab Small Fab	QC3 inspect chemical coat Memo 1- Instal nut and sleeve 2- Flare one end as per dwg.	0.00 0.00							
nut + sleeve done at Cintube as per dwg D4003 REV. A									
						CY	11/01/13		

Dart Aerospace Ltd

W/O: 63909		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Nov 13	#	Perm. change ADD step for Q13 (QTY. 5.)	BR	11.01.13 11-01-13			u12/13	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63909

Thursday, November 18, 2010 3:53:43 PM

Page 3

Item ID: D4003-049

Accept

Setup Start

Revision ID:

Stop

Item Name: Tank Vent Line Assembly

Start Date: 11/19/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

123



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

N/A CL 11/10/13

Memo

0.00

130



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

CL 11/18/13 (5)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CL 11/10/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, November 18, 2010 3:53:42 PM

Page 1

Work Order ID: 63909

Parent Item: D4003-049

Parent Item Name: Tank Vent Line Assembly

Start Date: 11/19/2010


Required Date: 12/3/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.01.05 new Issue Prelim EC verified by: DD IPP Rev B
10.05.13 ecn 10-562 EC verified by:DD


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN818-8D ✓  Nut		Purchased	No			122	Each	43.0000	1	2			
---	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

ST331	43	
114382	8	
114523	16	
114544	9	
115594	10	

D4003-049P ✓  TANK VENT LINE ASSEMBLY		Purchased	No			100	Each	0.0000	1	2			
---	--	-----------	----	--	--	-----	------	--------	---	---	--	--	--

MS20819-8D ✓  Sleeve		Purchased	No			122	Each	46.0000	1	2			
---	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

ST323	46	
113795	3	
114445	37	
115001	6	

m6061T6T0.500W.035 ✓

4692

x12/t C21011/22

C21011/22

B63909 C21101/13

C21011/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

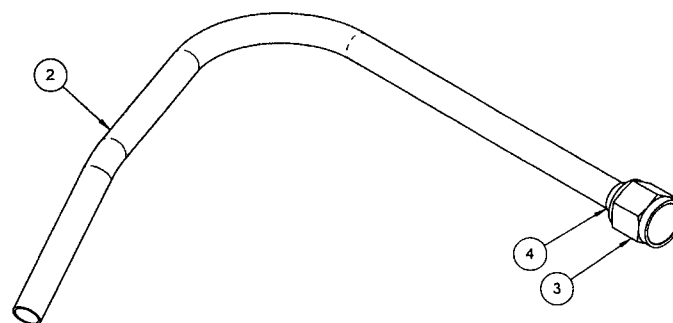
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -049	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4003-049	TANK VENT LINE ASSEMBLY	JCA-M47-2-17
2	1	D4003-9	VENT LINE	
3	1	AN818-8D	NUT	
4	1	MS20819-8D	SLEEVE	



D4003-049 TANK VENT LINE ASSEMBLY

RELEASED
R 2010-05-05
JWD

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4003-049" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.11 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4003	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		LINE	NTS
DATE	10.02.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

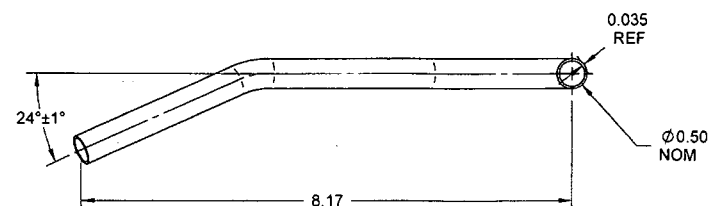
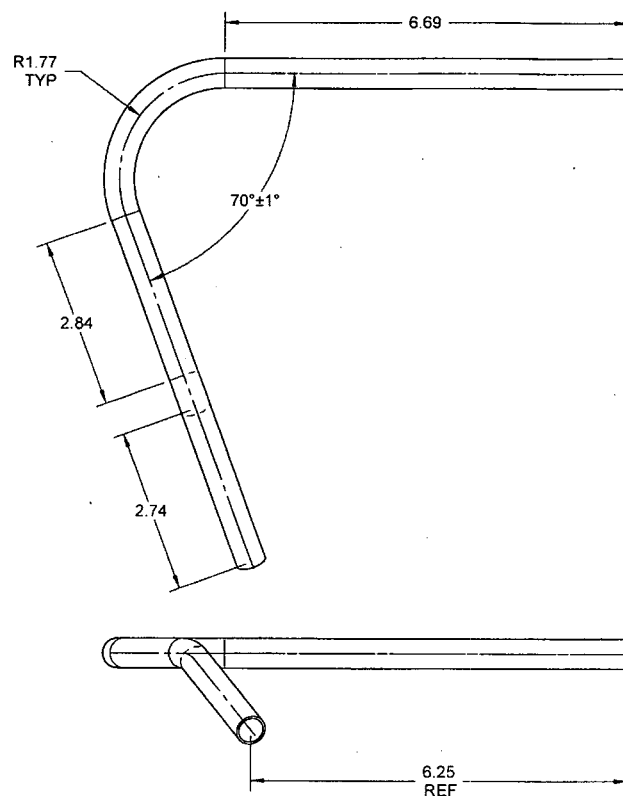
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-9	REF JCA-M47-2-17



63909

D4003-9 VENT LINE

RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, $\phi 0.500 \times 0.035$ WALL THICKNESS
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T60.500W.035
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D4003	SHEET 7 OF 9
APPROVED			TITLE	SCALE
DE APPR.			LINE	NTS
DATE	10.02.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD		
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO12968

Purchase Order Date 11/22/10

PO Print Date 11/22/10

Page Number 1 of 1

Order From :

VC-CIN001

CINTUBE LTEE
333 ST-JOSEPH BLVD
LACHINE, QC H8S 2K9
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	514 634 3592	Requisition Nbr	
Vendor Fax	514 636 3336	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
C710/11/22

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4003-049P	TANK VENT LINE ASSEMBLY	12/03/10 - Yes	5.00 Each	FedEx PI collect	\$175.0000	\$875.00

Special Inst: MANUFACTURE AS PER DWG D4003
REV. A
B63909
MATERIAL: 6061-T6 T0.500X.035 WALL
M4692 X 12FT
NUT: AN818-8D, M114544 X 5
SLEEVE: MS20819-8D, M115001 X 5

PO Total:

\$875.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 11/22/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

CLIENT:

DART AEROSPACE LTD.
1270 ABERDEEN ST.HAWKS BURY
ON K6A 1K7EXPED. A/TO :
SAME

M-112125

CINTUBE LTEE/LTD

☒ 333 BOUL. ST-JOSEPH, BUILDING # 105 ☐ 1250 MATHESON BLVD. EAST
LACHINE, QUEBEC MISSISSAUGA, ONTARIO
H8S 2K9 L4W 1R2
TEL: (514) 634-3592 TEL: (905) 625-190
FAX: (514) 636-3336 / 8625 FAX: (905) 625-1500

Rep: PATRICK ZALATAN

CLIENT

BON. LIVR.: RELACHE
M-112125
PACK. SLIP RELEASE

DATE: 23-Nov-10
COMMANDE #: PO12968
ORDER #:

CONTACT PHONE #: (613) 632-9577 EXT. #:

FAX #: (613) 632-1053

CLIENT NO.	MAT'L PAR / MAT'L BY	REFERENCE	MODE DE PAIEMENT / TERMS OF PAYMENT
MDAR72	CLIENT		1.5 % - 10 DAYS / NET 30
TRANSPORT		DATE LIV. / DELIV. DATE	CONTACT
PURCHASER COLLECT #7684382		10 A/TO 15 JOURS/DAYS	CHANTAL LAVOIE

QUANT	EXP.	DIMENSION / SIZE	EP / WALL	DESCRIP. MAT'L. / MAT'L DESCRIP.	DEG.	RAY. / RAD.	TANGENTE / TANGENT	INSTRUCTIONS
5	5	0.5 OD	0.035	PART NO. DART D4003-9 TUBE ALUMINIUM NUTS & SLEEVES BY DART LETTRE DE CONFORMITE	MULTIPLE BENDS	1.77 CLR	SEE DRWG: D4003-9	FINAL CUT & FLARE
1	1							

Notes:

CATEGORIE ISO
ISO CATEGORY

1	2	3
<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>

ASME ☐

LETTRE DE CONFORMITE
LETTER OF COMPLIANCE

OUI
YES ☒

DATE CLIENT AVIS / ADV.:

CONTACT:

PAR/BY:

DATE:

EXPEDIE PAR / SHIPPED BY:

DATE:

CLIENT:

CINTRAGE DE PRÉCISION, DE TUBES, TUYAUX, CORNIÈRES, POUTRES,
PROFILÉS EN "U", ET SERPENTINS.
MANUFACTURIER DE GÉNÉRATRICE À VAPEUR, ÉLÉMENT CHAUFFANT,
RÉCUPÉRATEUR DE CHALEUR, ÉCONOMISEUR ETC.

PRECISION BENDING OF TUBES, PIPES, ANGLES, BEAMS, CHANNELS, COILS.
MANUFACTURERS OF STEAM GENERATORS, THERMAL FLUID HEATERS,
WASTE HEAT RECOVERY UNITS, ECONOMIZERS.

333 BOUL. ST-JOSEPH, LACHINE, QUÉBEC H8S 2K9
TÉLÉPHONE: (514) 364-6426 FAX NO: (514) 636-3336

LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Client/Customer DART AEROSPACE Date: JAN.12/2011

N° de commande du client/Customer order No: P012968

Notre n° de feuille de route/Our order No: 112125

Notre n° de dessin/Our drawing No: —

Description/Customer drawing No: D-4003-9

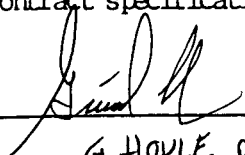

Nom de la pièce/Part Name: VENT LINE

DIMENSIONS ± 1/8" 5 pièces

La présente est pour certifier que le matériel ci-haut mentionné se conforme aux exigences contractuelles de qualité et/ou de la confirmation de la commande, qu'il a été produit, inspecté et testé selon les spécifications standards applicables de notre programme de contrôle de la qualité, du contrat et du(des) dessin(s).

This is to certify that the material covered by this document conforms to the quality requirements of the purchase order or contract, that the material has been produced, verified and tested according to applicable standard specifications listed in our quality control procedures, contract specifications and/or drawing(s).

Signé par/Signed by:

G. HOULE pour B. AVERBURY

Directeur des services techniques/Technical Services Director

Pour la Compagnie Cintube Ltée/On behalf of Cintube Ltd.

